

Work Order ID 67891

Monday, April 04, 2011 10:30:46 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4311-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Rappel Attachment

Start Date: 4/4/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 4.00

Customer:

Reference:



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4311

PA3

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut BLANK 7.00" LONG

Jul 11.04.05

2 0

110

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL AS PER DWG

DWG REV: *PA3*

Jul 11.04.05






2 0



DEBURR




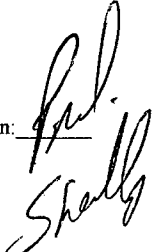
Work Order ID 67891

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Page 2

Item ID: D4311-1 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Rappel Attachment
Start Date: 4/4/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 4/6/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2	Ø		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2	Ø		
140  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00				2	0		

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Page 3

Item ID: D4311-1

Accept

Revision ID: PRELIM

Item Name: Rappel Attachment

Start Date: 4/4/2011 Start Qty: 4.00

Required Date: 4/6/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W 11.04.05

POSITIVE RECALL

EFFECTIVE 11.04.05 AUTH

RELEASED _____ DATE _____

AD2334

67890 Pulled
on D4311-041

Picklist Print

Monday, April 04, 2011 10:30:43 AM

Page 1

Work Order ID: 67891



Parent Item: D4311-1



Parent Item Name: Rappel Attachment

Start Date: 4/4/2011

Required Date: 4/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-04-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B1.500X02.250		Purchased	No			100	f	35.8333	0.583333	2.456139			
17-4 SS Bar 1.50 X2.250													

Location

MAT031

Loc Qty

35.8333

Loc Code

~~113568~~

1.08

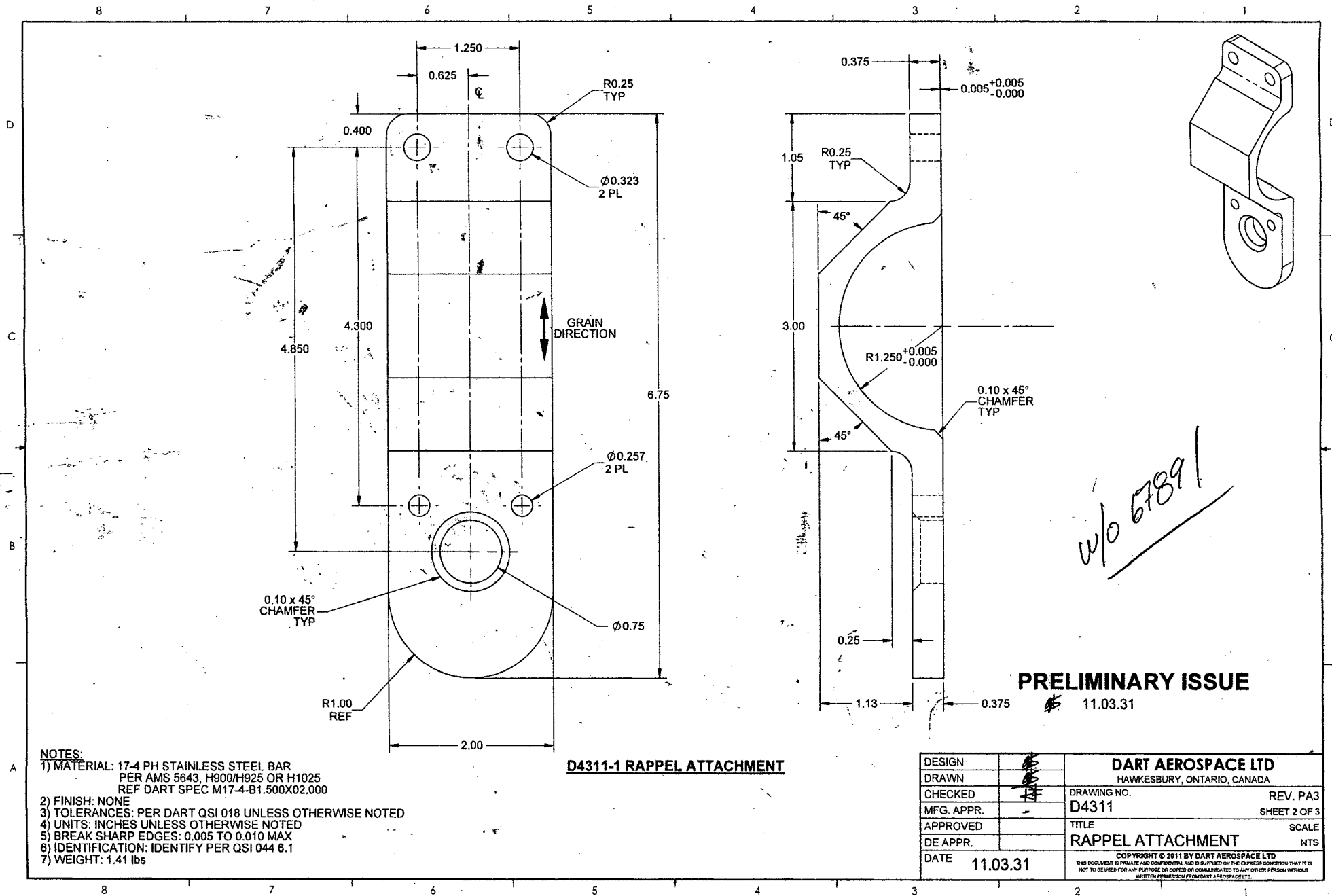
113568

11.8333

~~115806~~

22.92

~~14"~~
14"
JLM 11-04-04



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL BAR
PER AMS 5643, H900/H925 OR H1025
REF DART SPEC M17-4-B1.500X02.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.41 lbs

D4311-1 RAPPEL ATTACHMENT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4311	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RAPPEL ATTACHMENT	NTS
DATE	11.03.31	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 67891
Description: <i>Rappel Attachment</i>		Part Number: D4311-1
Inspection Dwg: D4311 Rev: PA3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.05	1.247	✓		LMV6	
4.00	+/-0.10	.398	✓			
4.850	+/-0.05	4.849	✓			
4.300	+/-0.05	4.298	✓			
Ø 323	+0.006 -0.007	Ø 326	✓			
Ø 257	+0.006 -0.007	Ø 258	✓			
Ø 750	+0.007 -0.007	Ø 752	✓			
6.75	+/-0.30	6.748	✓		LMV9	
2.00	+/-0.30	1.997	✓		LMV6	
.375	+/-0.10	.377	✓		LMV6	
1.13	+/-0.30	1.124	✓		H6	
3.00	+/-0.30	3.008	✓		LMV6	
R1.250						
R1.250	+0.005 -0.000	R1.254	✓		H-6	
10 x 45	+/-0.20 100x45°	100x45°	✓		LMV6	

Measured by: <i>[Signature]</i>	Audited by: J.F.S.	Preliminary Approval:
Date: 11.04.05	Date: 11/04/05	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15